

DART AEROSPACE LTD		Work Order:	22260
Description: Short Pin Bracket		Part Number:	D3330-13
Dwg: D3330 Rev. A PAGE 9 RF 05.01.17		Qty:	10
		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler 3.00	JP	05.01.17	10
2	MV	Cut blanks: 2.500" x 1.000" x 5.00 long (+/-0.030) Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel (M1010-B2.500x01.000) Identify for D3330-13 FA 479 Batch: M16332	EP	05/01/18	10
3	MV	Machine as per Folio EA 480 and Dwg D3330 Identify as D3330-13	FE	05.01.19	10
4	QC2	Inspect parts as they come off the CNC machine	CE	05.01.19	10
5	QC8	Second check	Er	05.01.19	10
6	MV	Deburr	FE	05.01.19	10
7	QC5	Inspect work to Step 6	Er	05.01.19	10
8	ST	Identify and Stock	CL	05/01/19	10
9	AC	Cost / part: 16.42	Sgc	05-01-20	10
10	DC	Close W/O 16.42 Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED
05/05/17

127 mm

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

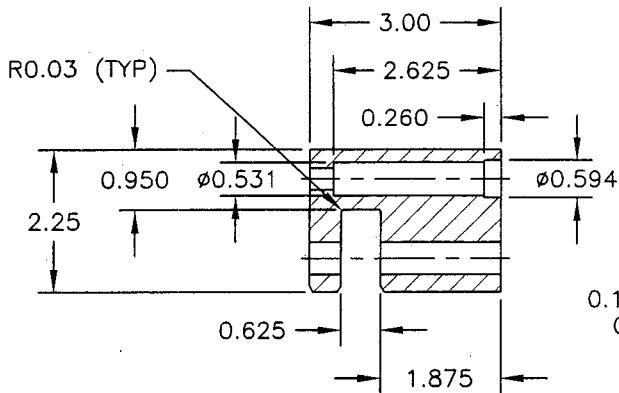
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

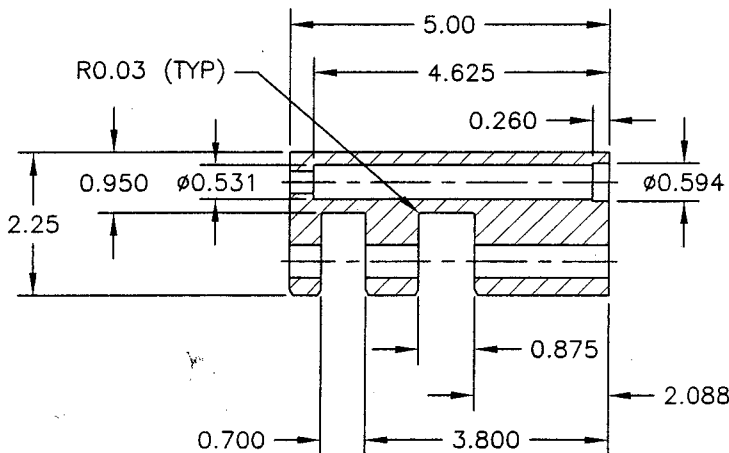
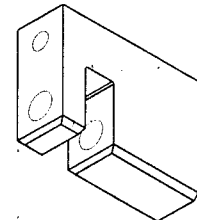
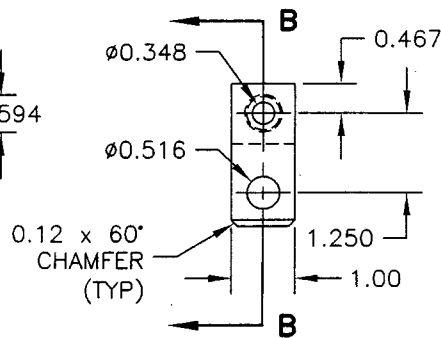


DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED	DRAWING NO. D3330	REV. A SHEET 9 OF 9
DATE 04.11.16		TITLE FRAME WELDMENT	SCALE 1:3



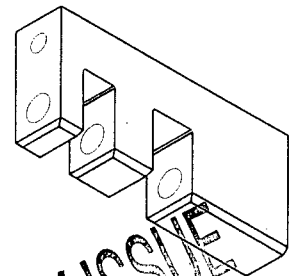
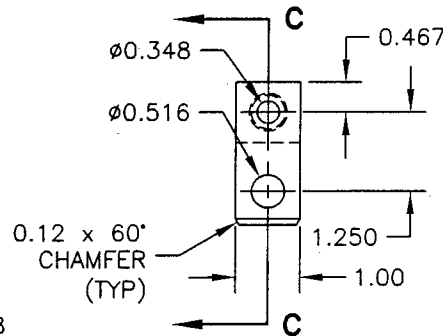
SECTION B-B

D3330-13 SHORT PIN BRACKET



SECTION C-C

D3330-11 LONG PIN BRACKET



NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

PRELIMINARY ISSUE

**SHOP COPY
RETURN TO
ENGINEERING**

**UNCONTROLLED COPY
SUBMIT
WORK
NO. 22260**

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No	:	0022260	Department Code:	
Project Name	:	D3330-13	Burden Flags	: NNNNNNNN
Project For	:		WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3330-13	Invoice Number	:
Description	:	Short Pin Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	10	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	01-17-05		
Est Finish Date	:		Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:			

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			



	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00

DART AEROSPACE LTD		Work Order:
Description:		Part Number: D3330 - B
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.00	± 0.03	3.045		✓		
2.625	± 0.01	2.632	✓			
0.260	"	0.262	✓			
Ø.594	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	Ø.595	✓			
1.875	± 0.01	1.878	✓			
0.625	"	0.628	✓			
2.25	± 0.03	2.247	✓			
0.950	± 0.01	0.946	✓			
Ø.531	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	Ø.534	✓			
Ø.467	± 0.01	Ø.475	✓			
1.250	± 0.01	1.248	✓			
1.00	± 0.03	0.998	✓			
0.120 x 60°	"	0.126 x 45°		✓		
Ø.516	$\begin{matrix} +0.005 \\ -0.000 \end{matrix}$	Ø.517	✓			
Ø.348	"	Ø.349	✓			

Measured by: 	Audited by: 	Prototype Approval:
Date: 05.01.19	Date: 05.01.19	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	